

Date: Wednesday, 26/09/2007 9:24:34 AM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : ARM |
| Job Number | : 34876 | | |
| Estimate Number | : 11048 | | |
| P.O. Number | : N/A | Part Number | : D28443 |
| This Issue | : 26/09/2007 S.O. No.: N/A | Drawing Number | : D2844 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type: MACHINED PARTS | Drawing Revision | : A |
| Previous Run | : 34001 | Material | : N/A |
| Written By | : _____ | Due Date | : 03/10/2007 |
| Checked & Approved By | : _____ | Qty: | 15 Um: Each |
| Comment | : Est: B 0011.01 Removed P/O for Powder Coat - in house processEC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TRO500W035 | 304 RD Tube .500 x .035W |
|-----|----------------|--------------------------|



Comment: Qty.: 1.8533 f(s)/Unit Total: 27.7988 f(s)

304 RD Tube .500 x .035W

M304TRO500W035

Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 19.82" long (Hole ctr. to hole ctr.) using Jig

DT 8012

Batch M105575

645
205/8

SB 07/09/26 (15)

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: BAND SAW

Form per Dwg D2844 using brake and bending Jig DT 8238-B

Deburr

SAD 07-09-27 (15)
D M 07/09/26 (15)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

G A/c 9/07 (15) center

| | | |
|-----|----------------|----------------|
| 4.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M105008 W 07-10-05 C (15)
M105008 BL 07-09-28 (P10)

| | | |
|-----|-----|---|
| 5.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

G A/c 10/03

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2844-3 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: 2 Date: 07/10/10
 QA: N/C Closed: _____ Date: _____

| NCR: 34876 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|---|--------------------------------|---|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07-10-09 | 4 | 10 Arms were found with the die from the mat. coming through the Powder coat. | OS/10/12 | Remove Powder coat entirely and clean and remove the marks. | 07-10-09 | 07/10/03 | OS/10/12 | OS/10/03 |
| | | Ric. Die marker was too deep and not closed enough. | | Re Powder coat as per Q52 005. | 07-10-09 | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34876

Part Number: D28443

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure parts are still as per dwg D2844

Ed 02/10/07

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 265

Ed 7/10/07

(15)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Ed 07-10-07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

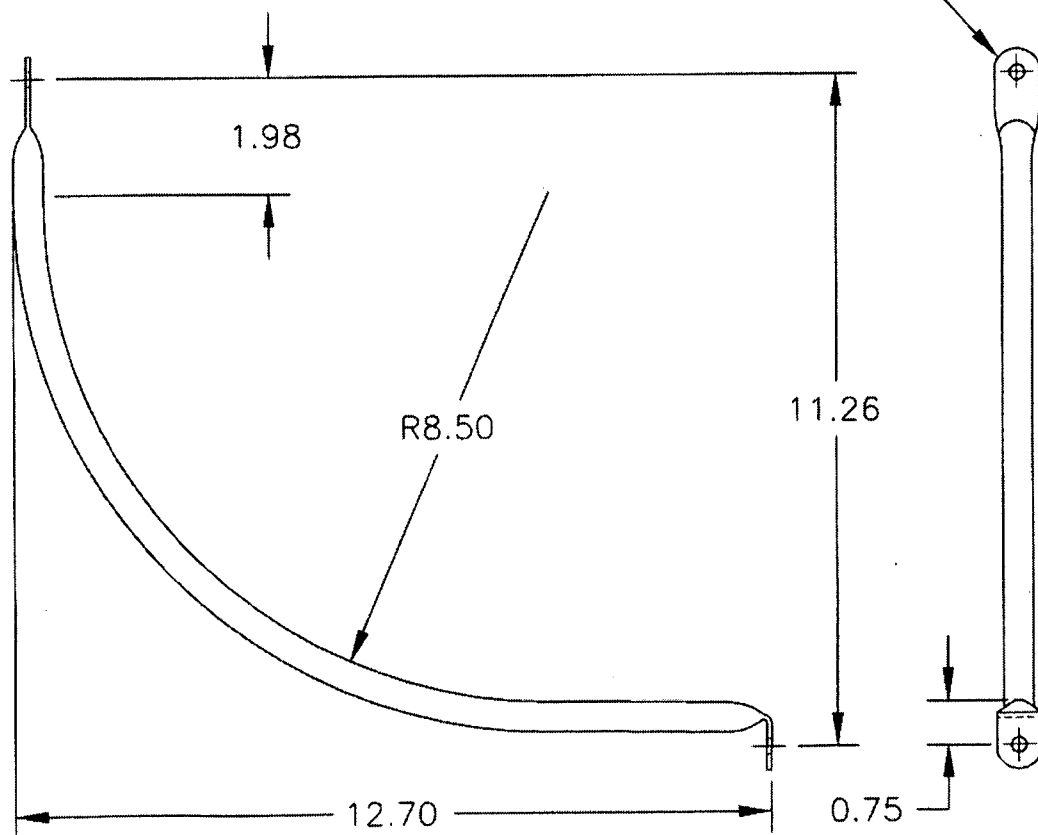
NOTE: Date & initial all entries



| | | | |
|-----------------------|--------------------------------|---|------------------------|
| DESIGN <i>KE</i> | DRAWN BY <i>KE</i> | DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA | |
| CHECKED <i>DAH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2844 | REV. A SHEET 2 OF 2 |
| DATE 98.10.14 | TITLE ARM | | SCALE 1:3 |

RELEASED
98.11.11 *KE*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\varnothing 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3